

Date: Tuesday, 13/05/2008 11:08:48 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG		
Job Number	: 39240		Part Number	: D2591		
Estimate Number	: 10008		Drawing Number	: D2591 REV D		
P.O. Number	:		Project Number	: N/A		
This Issue	: 13/05/2008		Drawing Revision	: D		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 05/06/2008		
Previous Run	: 38441		Qty:	100	Um:	Each
Written By	:		Comment	: Est Rev:l Removed from 9 Digit 05-10-25 JLM		
Checked & Approved By	: JUO 08.5.13					
Comment	:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"	
		Comment: Qty.: 0.2340 f(s)/Unit Total : 23.4000 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: M108070	23.4 88 08/05/22
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 2.700" long	8.5 08/05/22 100
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		RG Comment: HAAS CNC VERTICAL MACHINING #1 machine per dwg D2591 REV. D 1- Machine as per Folio FA 039 and Dwg D2591 2-Deburr if required	100
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE read + inspect for transit damage ensure CFC attached	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	100
5.0	Q08	SECOND CHECK	
		Comment: SECOND CHECK inspect level 5	100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 8/6/13

(150)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.06.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39240
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

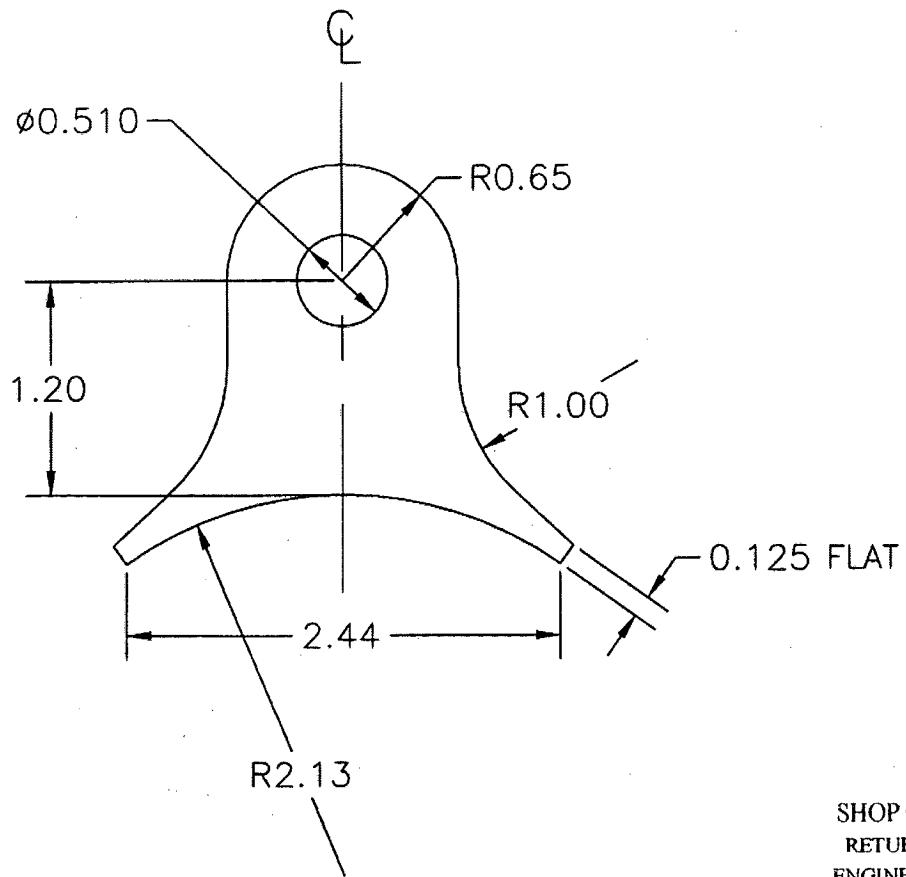
Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DS1 9161-011	KJ/JLM	<i>[Signature]</i>

DART**RELEASED**

98.01.21 DS

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
KE	BW	D2591	SHEET 1 OF 1
DATE	TITLE		SCALE
98.01.21	GHW LUG		1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 39240

00.04.05
0.063

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D2591	Lug B39240	6425
MATERIAL: supplied by DART M1010B0750X02500 M108090			

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shig Walz".

Shig Walz

Vankleek Hill, June 10, 2008